

ABSTRACT

5 A process for productive an easy-open can lid made  
of a resin laminated metal sheet comprising laminating a  
metal sheet or surface-treated metal sheet on one or both  
surfaces thereof with a crystalline saturated polyester  
resin film having a thickness of 10 to 100  $\mu\text{m}$ , an  
elongation of at least 150%, a degree of crystallinity of  
not more than 10%, and a heat of fusion of crystalline of  
10 not less than 10 joules/g, to form a laminated metal  
sheet for an easy-open can, forming by a composite cold-  
forming method a tear-along grooves of a residual  
thickness of not more than 1/2 of the thickness of the  
material using top and bottom dies of a die radius of 0.1  
15 to 1.0 mm, then heat treating the crystalline saturated  
polyester resin layer at the portion surrounding the  
tear-along groove at a temperature of at least the  
crystallization starting temperature and less than the  
melting point thereof and, also, an easy-open can lid  
20 obtained by the same and a resin laminated metal sheet  
used for the same.